

Work Order ID 52354 -3

Tuesday, September 22, 2009 12:26:55 PM

Split



Page 1

Item ID: D3023-1

Revision ID: A

Item Name: Back Panel

Start Date: 9/23/2009

Required Date: 10/9/2009

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100



Waterjet

FLOW CNC Waterjet

2-11
1055

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

B 9-11-5

3

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 9-11-5

Work Order ID 52354

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Page 2

Item ID: D3023-1

Accept

Revision ID: A

Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/9/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Work Order ID 52354

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Page 3

Item ID: D3023-1

Accept



Setup Start



Revision ID: A

Item Name: Back Panel

Stop



Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

1 bbl 10-12-16

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

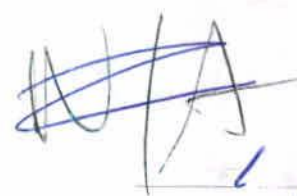
0.00

START TIME: 8:00
3:00

□ OVER TEMPERATURE

□ FINISH TIME:

8:00



1 bbl 10-12-17

10.02.03

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10/12/17

1 - 0

Work Order ID 52354

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Page 4

Item ID: D3023-1

Revision ID: A

Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/9/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *w/o*

0.00



Packaging

Memo

B 64542

0.00

Packaging

*~~10-12-09~~
10-12-09*

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

*10/12/2009**mk
10-12-10*

Picklist Print

Tuesday, September 22, 2009 12:26:55 PM

Page 1

Work Order ID: 52354

Parent Item: D3023-1RevA

Parent Item Name: Back Panel


Comments:

Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	94.2179	18.1749	10.0		
<div>  </div>												
2024-T3 .032 sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	94.21793158	
102942	1.5	
105555	4.0684	
106272	5.3	
108595	3	
109240	7.02	
110778	23.9106316	
111699	46.4189	
18147	3	
113005		

113005

B 9-11-5

DART AEROSPACE LTD		Work Order:	52354
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	130	X			
Ø0.191	+0.005/-0.001	194	X			
1.660	+/-0.010	1.666	X			
0.375	+/-0.010	0.377	X			
1.340	+/-0.010	1.344	+			
2.375	+/-0.010	2.373	X			
0.375	+/-0.010	0.373	X			
25.28	+/-0.030	25.28	X			
27.03	+/-0.030	27.03	X			
28.10	+/-0.030	28.10	X			
1.30	+/-0.030	1.297	X			
2.375	+/-0.010	2.373	X			
8.711	+/-0.010	8.712	X			
5.597	+/-0.010	5.598	X			
8.57	+/-0.030	8.571	X			
1.970	+/-0.010	1.967	X			
7.42	+/-0.030	7.40	+			
10.92	+/-0.030	10.92	+			
14.75	+/-0.030	14.75	X			

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-5	Date: 01/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

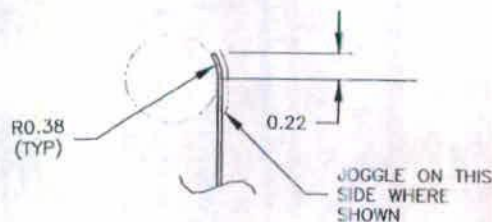
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

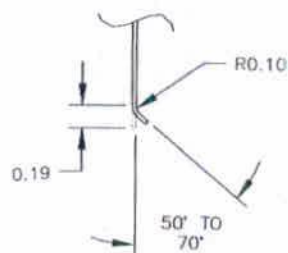
WITHOUT NOTICE
WORK ORDER

NO. 52354

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

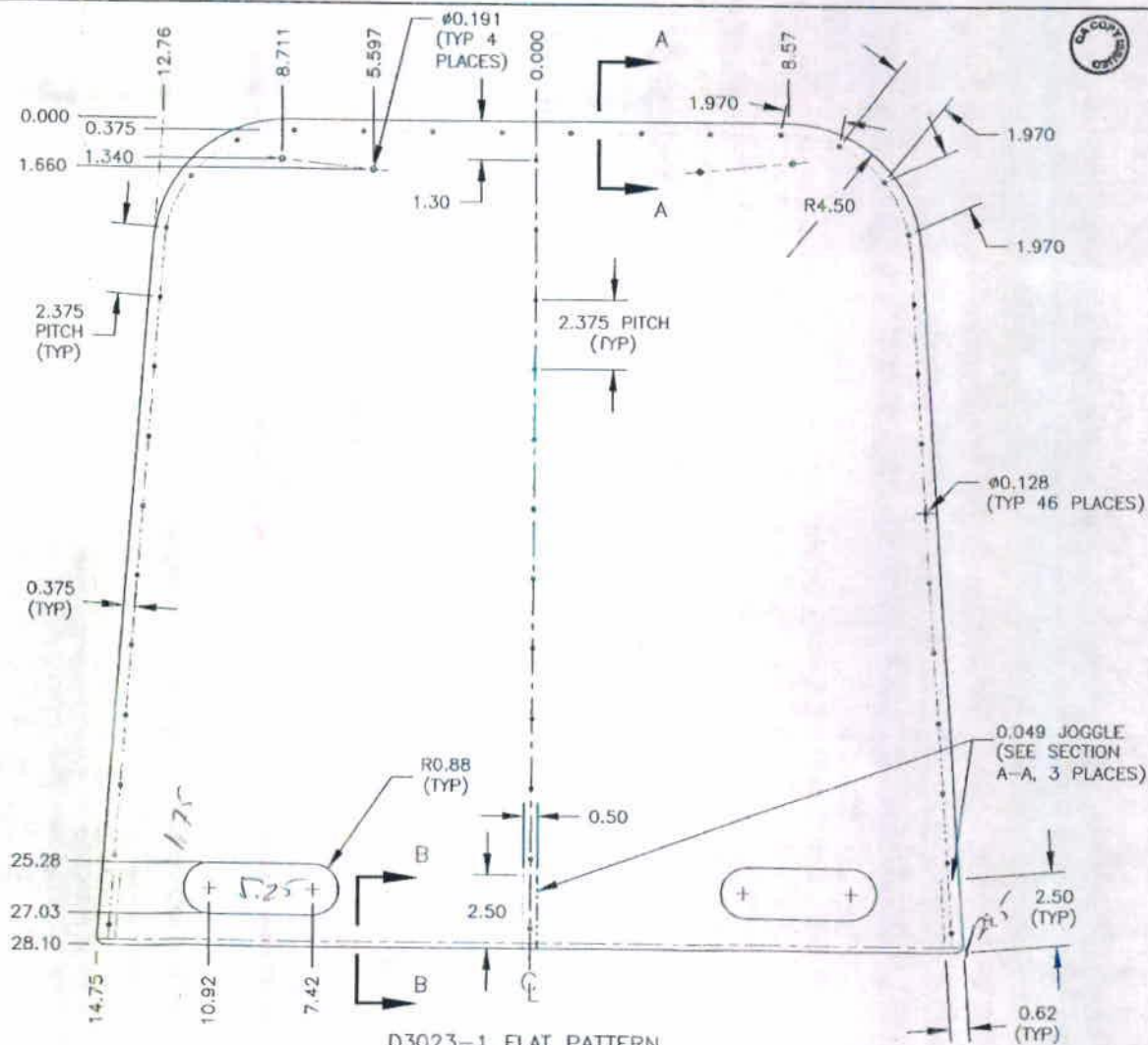


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	01.05.18	TITLE
		BACK PANEL
		DART AEROSPACE LTD. WARRINGTON, CHESHIRE, ENGLAND
		DRAWING NO. D3023
		REV. A SHEET 1 OF 1
		SCALE 1:1